

# Work Order ID 83109

**\*83109\***

Page 1

Friday, April 13, 2012 8:21:11 AM

Item ID: D350-600-249

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacepod Upgrade

Start Date: 4/12/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan:

Date: *12-04-12* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev C

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP 350-600-249 CHG001

0.00

0.00

*12/11/29*

110

**\*110\***

Packaging

Packaging

Packaging

Memo

Packaging

*Pick Kit*

0.00

0.00

120

**\*120\***

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

*12/11/29*

*1 12/11/27 20*

*12/11/27 20*

*80*

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83109

**\*83109\***

Page 2

Friday, April 13, 2012 8:21:11 AM

Item ID: D350-600-249

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Spacepod Upgrade

Start Date: 4/12/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-249								
	Location: <u>PK 033</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*(Handwritten: 12/1/12, 20, 8-89)*

*(Handwritten: 12/12/13)*

*(Handwritten: 12-12-03)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Friday, April 13, 2012 8:21:28 AM

Page 1

Work Order ID: 83109

\*83109\*

Parent Item: D350-600-249

\*D350-600-249\*

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 07.01.31 EC  
11.02.07 added missing AN960JD8 washer DD  
verf:JLM  
REV:A 11.04.27 added 1 D3554-7 DD verf:EC

IPP Rev:B

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C832R24

Purchased

No

110

Each

85.0000

4

4

\*AN526C832R24\*

screw

SmB

Location

Loc Qty

Loc Code

ST348

85

118870

85

120

Each

314.0000

1

1

A3235-020-935

Purchased

No

\*A3235-020-935\*

Washer - Countersunk

SmB

Location

Loc Qty

Loc Code

ST280

314

106150

314

120

Each

103.0000

10

10

AN526C832R10

Purchased

No

\*AN526C832R10\*

Screw

SmB

Location

Loc Qty

Loc Code

ST347

103

115101

5

118853

98

120

Each

416.0000

6

6

AN526C832R14

Purchased

No

\*AN526C832R14\*

Screw

SmB

Location

Loc Qty

Loc Code

ST348

416

104916

416

104916

12/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, April 13, 2012 8:21:28 AM

Work Order ID: 83109

\*83109\*

Parent Item: D350-600-249

\*D350-600-249\*

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-5A

Purchased

No

120

Each

57.0000

\*AN5-5A\*

Bolt

SMB

Location

Loc Qty

Loc Code

ST337

57

110865

57

0.0000

\*\* 1 ✓

1

✓

20



AN960JD10

NAS1149D0363J

Purchased

No

120

Each

0.0000

\*AN960.ID10\*

Washer

SMB

Location

Loc Qty

Loc Code

ST337

57

110865

57

0.0000

\*\* 1 ✓

1

✓

110865  
122378 20



AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

0.0000

\*AN960.ID10I \*

Washer

SMB

Location

Loc Qty

Loc Code

ST337

57

110865

57

0.0000

\*\* 1 ✓

1

✓

122973 20



AN960JD516

NAS1149D0563J

Purchased

No

120

Each

0.0000

\*AN960.ID516\*

Washer

SMB

Location

Loc Qty

Loc Code

ST337

57

110865

57

0.0000

\*\* 4 ✓

4

✓

123355 20



AN960JD8

NAS1149DN832

Purchased

No

120

Each

0.0000

\*AN960.ID8\*

Washer

SMB

Location

Loc Qty

Loc Code

ST337

57

110865

57

0.0000

\*\* 24 ✓

24

✓

123348 20



D2228

Manufactured

No

120

Each

41.0000

\*D2228\*

Bracket Plate

SMB

Location

Loc Qty

Loc Code

ST008

41

64427

3

73380

38

\*\* 2 ✓

2

✓

20

12/11/27



73380

Friday, April 13, 2012 8:21:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, April 13, 2012 8:21:28 AM

Work Order ID: 83109

**\*83109\***

Parent Item: D350-600-249

**\*D350-600-249\***

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2237

Manufactured No

120

Each

55.0000

**\*D2237\***

Striker Plate

*SM*

\*\*

1

89925 JB

Location

Loc Qty

Loc Code

ST006

55

66139

1

82062

54

D2464

Manufactured No

120

f

86.9711

**\*D2464\***

3/4 Seal

*SM*

\*\*

3.157895

83543 JB

Location

Loc Qty

Loc Code

ST404

86.9711

61878

86.9711

(D2464-0360) cut (1) at 36.00" per kit

D3015-3

Manufactured No

120

Each

200.0000

**\*D3015-3\***

Locknut

*SM*

\*\*

2

1x91863 JB

1x92381

Location

Loc Qty

Loc Code

ST023

200

78314

200

D3538-1

Manufactured No

120

Each

3.0000

**\*D3538-1\***

Hinge Bracket

*SM*

\*\*

2

84029 JB

12/11/27

Location

Loc Qty

Loc Code

ST054

3

73381

3

Friday, April 13, 2012 8:21:28 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, April 13, 2012 8:21:28 AM

Work Order ID: 83109

**\*83109\***

Parent Item: D350-600-249

**\*D350-600-249\***

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3547-1

Manufactured No

120

Each

1.0000

1

**\*D3547-1\***

Bracket

Sm

Location

Loc Qty

Loc Code

ST054

1

67604

1

120

Each

2.0000

1

D3550-1

Manufactured No

**\*D3550-1\***

Strut

Sm

Location

Loc Qty

Loc Code

ST271

2

69040

2

120

Each

4.0000

1

D3552-7

Manufactured No

**\*D3552-7\***

Door Prop

Sm

Location

Loc Qty

Loc Code

ST272

4

73382

4

120

Each

10.0000

2

D3554-7

Manufactured No

**\*D3554-7\***

Ball Stud

Sm

Location

Loc Qty

Loc Code

ST054

10

73383

10

120

Each

23.0000

1

D3557-1

Manufactured No

**\*D3557-1\***

Bracket

Sm

Location

Loc Qty

Loc Code

ST054

23

73384

23

12/11/27

Friday, April 13, 2012 8:21:28 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, April 13, 2012 8:21:28 AM

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Work Order ID: 83109

\*83109\*

Parent Item: D350-600-249

\*D350-600-249\*

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

120

Each

4,860.000

2

2

\*MS20426AD4-5\*

Rivet

Smb

Location

Loc Qty

Loc Code

ST317

4860

6874

4860

6874

MS21042108

Purchased

No

120

Each

248.0000

22

22

\*MS210421 08\*

Nut

Smb

Location

Loc Qty

Loc Code

ST300

248

120833

200

121185

48

MS2104213

Purchased

No

120

Each

2,981.000

2

2

\*MS210421 3\*

Nut

Smb

Location

Loc Qty

Loc Code

ST300

2981

117441

16

117885

32

118451

5

118927

3

119017

1759

119075

166

121349

1000

12326520

12/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Friday, April 13, 2012 8:21:29 AM

Work Order ID: 83109

**\*83109\***

Parent Item: D350-600-249

**\*D350-600-249\***

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

120

Each

1,421.000

\*\* 

1

122450 JB



**\*MS21042L5\***

Nut

SmB

## Location

## Loc Qty

## Loc Code

ST300

1421

116105

5

116548

43

117611

38

119109

1335

MS24694-S69


Purchased

No

120

Each

60.0000

\*\* 

1

JB



**\*MS24694-S69\***

Screw

SmB

## Location

## Loc Qty

## Loc Code

ST289A

60

112492

60

120

Each

69.0000

\*\* 

2

112492

JB



MS27039-08-11

Purchased

No

120

Each

69.0000

\*\* 

2

**\*MS27039-08-11\***

Screw

SmB

## Location

## Loc Qty

## Loc Code

ST290

19

117441

19

ST292

50


120833

50

120

Each

51.0000

\*\* 

1

120833

JB

12/11/27



MS27039-1-25


Purchased

No

120

Each

51.0000

\*\* 

1

**\*MS27039-1-25\***

Screw

SmB

## Location

## Loc Qty

## Loc Code

ST292

51

102602

51

102602

Friday, April 13, 2012 8:21:29 AM

Shop Packet Print

Page 6

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 83109

\*83109\*

Parent Item: D350-600-249

\*D350-600-249\*

Parent Item Name: Spacepod Upgrade

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

~~NAS1515H3~~

Purchased

No

120

Each

158.0000

2

2

\*\*

123301 JB

12/11/27

\*NAS1515H3\*

Washer

SMB

Location

Loc Qty

Loc Code

ST277

158

118078

6

118384

11

119438

4

120142

11

120518

26

120770

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D350-600

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
									<del>D2464-0360</del>	<del>NEOPRENE SEAL</del>
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	<del>1</del>		<del>D3015-3</del>	<del>LOCK NUT</del>
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	<del>1</del>		<del>D3547-1</del>	<del>BRACKET</del>
1	1	1			1	1	<del>1</del>		<del>D3550-1</del>	<del>STRUT</del>
			1	1	1	1	<del>1</del>		<del>D3552-7</del>	<del>GAS SPRING</del>
1	1	1			1	1	<del>1</del>		<del>D3554-7</del>	<del>BALL STUD</del>
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	<del>1</del>		<del>AN5-5A</del>	<del>BOLT</del>
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	<del>4</del>		<del>AN526G832R14</del>	<del>SCREW</del>
7	7	7							MS24694S67	SCREW
1	1	1			1	1	<del>1</del>		<del>MS24694S69</del>	<del>SCREW</del>
			2	2	2	2	<del>2</del>		<del>MS27039-0811</del>	<del>SCREW</del>
8	8	8			1	<del>1</del>	<del>1</del>		<del>AN3235-020-935</del>	<del>WASHER</del>
8	8	8							AN960JD10	WASHER
16	16	16			1	1	<del>1</del>		<del>AN960JD10L</del>	<del>WASHER</del>
			4	4	8	8	<del>8</del>		<del>AN960JD8</del>	<del>WASHER</del>
3	3	3			3	3	<del>3</del>		<del>AN960JD516</del>	<del>WASHER</del>
			2	2	2	2	<del>2</del>		<del>NAS1515H3</del>	<del>NYLON WASHER</del>
			2	2	6	6	<del>6</del>		<del>MS21042L08</del>	<del>NUT</del>
16	16	16			1	1	<del>1</del>		<del>MS21042L3</del>	<del>NUT (or MS21042-3)</del>
1	1	1			1	1	<del>1</del>		<del>MS21042L5</del>	<del>NUT</del>
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Date: 09.07.31

# REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D350-600

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-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	<del>1</del>		<del>MS27039-1-25</del>	<del>SCREW</del>
			2*	2*	2	2	<del>1</del>		<del>AN960JD8</del>	<del>WASHER</del>
			2*	2*	2	2	<del>1</del>		<del>MS21042L03</del>	<del>NUT (or MS21042-3)</del>
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	<del>8</del>		<del>AN526C832R10</del>	<del>SCREW</del>
			8*	8*	8	8	<del>8</del>		<del>AN960JD8</del>	<del>WASHER</del>
			8*	8*	8	8	<del>8</del>		<del>MS21042L08</del>	<del>NUT</del>
			1*	1*	1*	1*	<del>1</del>		<del>D3557-1</del>	<del>BRACKET</del>
			2*	2*	2*	2*	<del>2</del>		<del>D2228</del>	<del>BACKING PLATE</del>
			1*	1*	1*	1*	<del>1</del>		<del>D3554-7</del>	<del>BALL STUD</del>
			1*	1*	1*	1*	<del>1</del>		<del>AN960JD516</del>	<del>WASHER</del>
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	<del>2</del>		<del>AN526C832R14</del>	<del>SCREW</del>
			2*	2*	2*	2*	<del>2</del>		<del>AN526C832R10</del>	<del>SCREW</del>
			4*	4*	4*	4*	<del>4</del>		<del>AN960JD8</del>	<del>WASHER</del>
			4*	4*	4*	4*	<del>4</del>		<del>MS21042L08</del>	<del>NUT</del>
2**	2**	2**			1	1	<del>1</del>		<del>D2237</del>	<del>STRIKER PLATE</del>
4**	4**	4**			2	2	<del>2</del>		<del>MS20426AD4-5</del>	<del>RIVET</del>
2**	2**	2**			2	2	<del>2</del>		<del>D3538-1</del>	<del>HINGE BRACKET</del>
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	<del>4</del>		<del>AN526C832R24</del>	<del>SCREW</del>
4**	4**	4**			4	4	<del>4</del>		<del>AN960JD8</del>	<del>WASHER</del>
4**	4**	4**			4	4	<del>4</del>		<del>MS21042L08</del>	<del>NUT</del>

\* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

\*\* PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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